

Work Order ID 61177

August 11, 2010 7:42:25 AM



Page 1

Item ID: D3827-041

Accept



Setup Start



Revision ID:

Stop



Item Name: Rib Assembly (Inboard)

Start Date: 8/11/10 Start Qty: 6.00



Cust Item ID:

Required Date: 8/17/10 Req'd Qty: 6.00



Customer:

Reference:

Approvals:

Process Plan: CZ

Date: 10/8/11

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3827

Rev A

100

0.00



Large Fab

Large Fab

Memo

0.00

Large Fab

1- cut D3827-1 rib as per dwg D3827

2- drill holes using DT9435 jig and open to finish size as per dwg D3827

3- c'sink as per dwg

4- remove identification markings

5- deburr

SAD 10-08-11

6- weld bushing in rib as per dwg D3827

A/R S.S. Rod Batch: M114649

7- grind weld flush

8- deburr if necessary

RD 10-08-19

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 61177

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Item ID: D3827-041

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Start Date: 8/11/10 Start Qty: 6.00



Cust Item ID:

Required Date: 8/17/10 Req'd Qty: 6.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 QC Quality Control	QC10- Inspect visual per QSI004- ground welds Memo	0.00 0.00				6			100818
140 QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00				6			100818
150 Packaging Packaging	Identify as per dwg & Stock Location: <u>WA</u> Memo	0.00 0.00				②			SAB 10-08-18

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

Work Order ID 61177

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Item ID: D3827-041

Accept



Setup Start



Revision ID:

Stop



Item Name: Rib Assembly (Inboard)

Start Date: 8/11/10 Start Qty: 6.00



Cust Item ID:

Required Date: 8/17/10 Req'd Qty: 6.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start



Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/08/19

MF
10-8-19

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

August 11, 2010 7:42:25 AM

Page 1

Work Order ID: 61177

Parent Item: D3827-041

Parent Item Name: Rib Assembly (Inboard)



Start Date: 8/11/10

Required Date: 8/17/10

Start Qty: 6.00

Required Qty: 6.00

Comments: IPP Rev:A 08-12-01 new issue DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3759-1  Bushing		Manufactured	No			100	Each	119.0000	3	18			
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				ST084				60					
				56942				60					
				WA				59					
				54072				9					
				60241				8					
				60719				42					
M304TS0.750W.065  304 SQ Tube .75x.75x.065W		Purchased	No			100	f	489.2170	8	50.52632			
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				MAT				1.4628					
				112398				0					
				114482				1.4628					
				WA				487.754185					
				114520				22.417985					
				115274				465.3362					

AD 10.03.10

⑧
⑧

SAD 10-08-12

50.5264

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

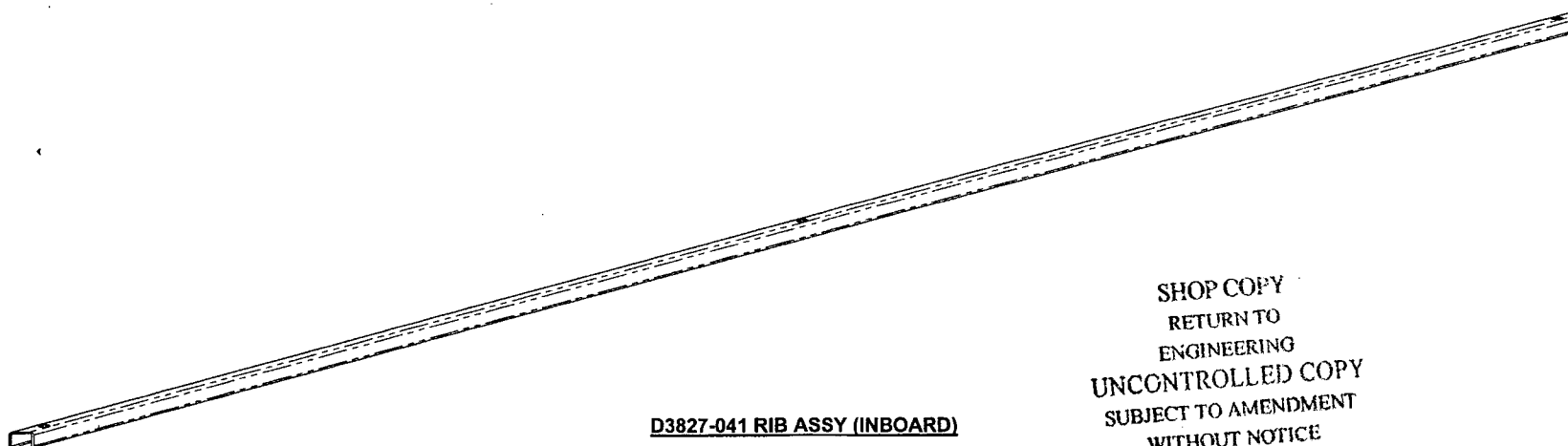
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

ITEM	QTY -041	P/N	DESCRIPTION
1	X	D3827-041	RIB ASSY (INBOARD)
2	3	D3759-1	BUSHING
3	1	D3827-1	RIB



D3827-041 RIB ASSY (INBOARD)

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WITHOUT NOTICE
WORK ORDER
NO. 601177
C210811

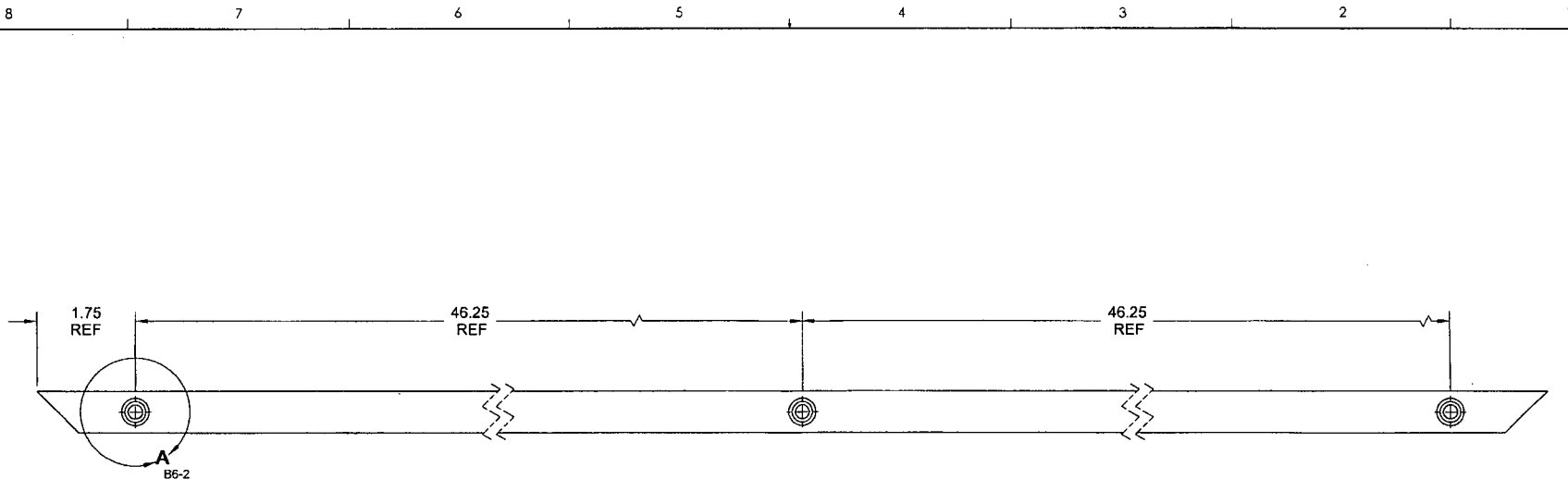
RELEASED
08/11/14

- NOTES:
1) MATERIAL: N/A
2) FINISH: NONE
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: N/A
7) WEIGHT: 4.59 lbs

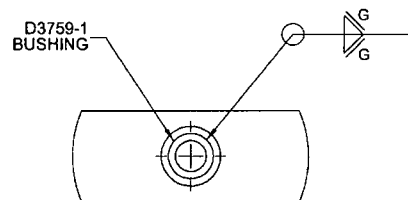
A	NEW ISSUE	MB	08.09.23
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED	<u>ASS</u>		
MFG. APPR.	<u>MB</u>		
APPROVED	<u>MB</u>		
DE APPR.	<u>MB</u>		
DATE	08.09.23		

DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWING NO. D3827	REV. A
TITLE RIB ASSY (INBOARD)	SHEET 1 OF 3
SCALE NTS	

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D3827-041 RIB ASSY (INBOARD)

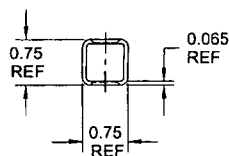
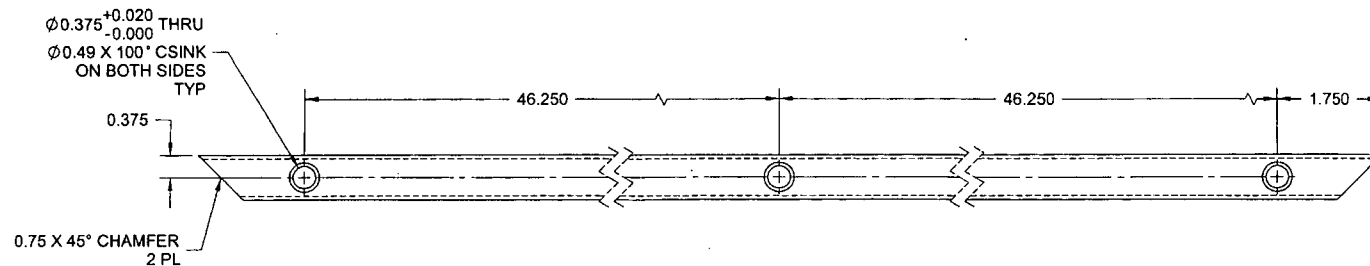


DETAIL A C7-2
SCALE 2X
3 PL

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08/11/18

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MFG. APPR.	<i>MP</i>	SHEET 2 OF 3	
APPROVED	<i>MP</i>	TITLE	SCALE
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D3827-1 RIB

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 WITHOUT NOTICE
 WORK ORDER
 NO. 61177

RELEASED
 08/11/18/WP

- NOTES:
- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SQUARE TUBE, 0.75 X 0.75 X 0.065 WALL
REF. DART SPEC. M304TS0.750W0.065
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: 4.55 lbs

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MFG. APPR.		D3827	SHEET 3 OF 3
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